

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. C

REF. CANADIAN STC: SH92-18

REF. FAA STC: SH989NE/SH990NE

To make the Dart D350-567-111 Vertical Reference Window Installation Kit at CHG 002 and D350-567-115 Interior Floor Window Kit at CHG 001 compatible with later AS350/355 Aircraft, it may be necessary to notch and reinforce the D3294-1 Bracket per Figure 1. This change is required to ensure that the D3294-1 Bracket will not interfere with the pilot's right hand aft seatbelt anchor structure.

Procedure

- 1) Notch D3294-1 Bracket per Figure 2. Figure 2 represents the maximum size of the notch. Maintain a minimum edge distance of 0.125in from the edge of the holes.
- 2) Touch up affected areas on D3294-1 Bracket with chemical film (Alodine 1200/1201) per MIL-C-5541 before painting. Apply one coat of MIL-P-85582/MIL-P-23377 primer and 2-3 coats of MIL-C-83285 polyurethane paint to match original finish.
- 3) Prepare doubler per Figure 3. Figure 3 represents the minimum size of the doubler.
- 4) Prepare the doubler for paint with chemical film (Alodine 1200/1201) per MIL-C-5541. Apply one coat of MIL-P-85582/MIL-P-23377 primer and 2-3 coats of MIL-C-83285 polyurethane paint to match finish and color on D3294-1 Bracket.
- 5) Install Doubler on D3294-1 Bracket using MS20470AD4 Rivets as shown in Figure 1.
- 6) Install the modified D3294-1 Bracket in accordance with Installation Instructions D350-567.

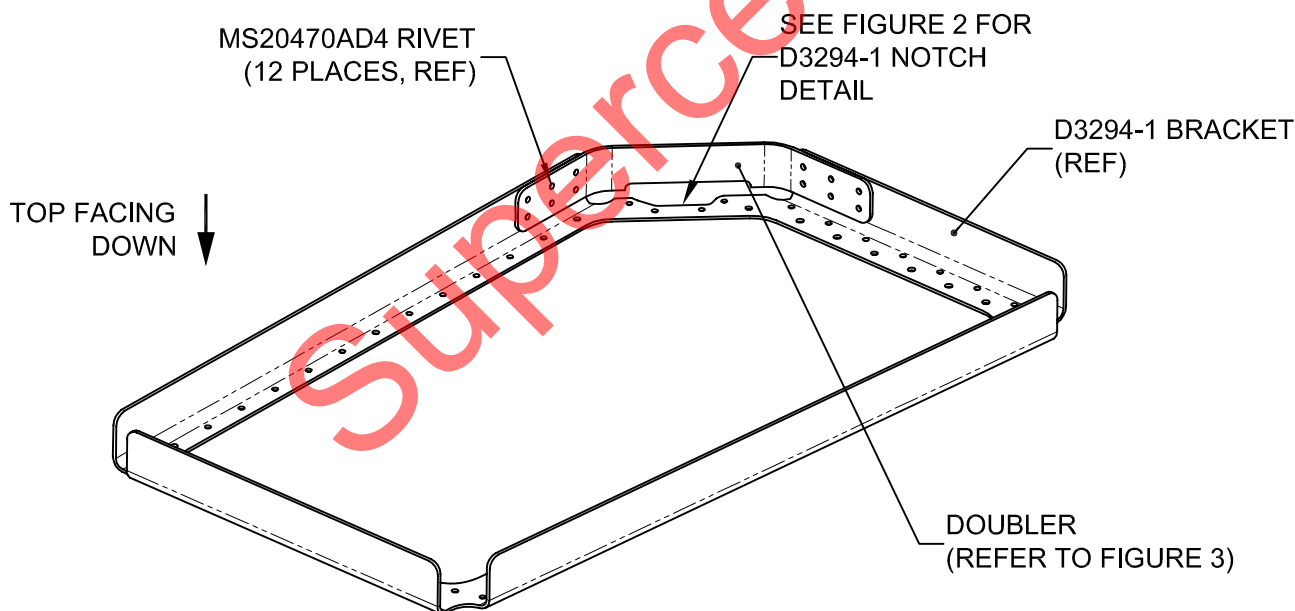


FIGURE 1: INSTALLATION OF DOUBLER

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY:

D. SHEPHERD (DE # 02)

DATE: 07.10.05

CERT. NO.: SH92-18

ISSUE NO.: 5

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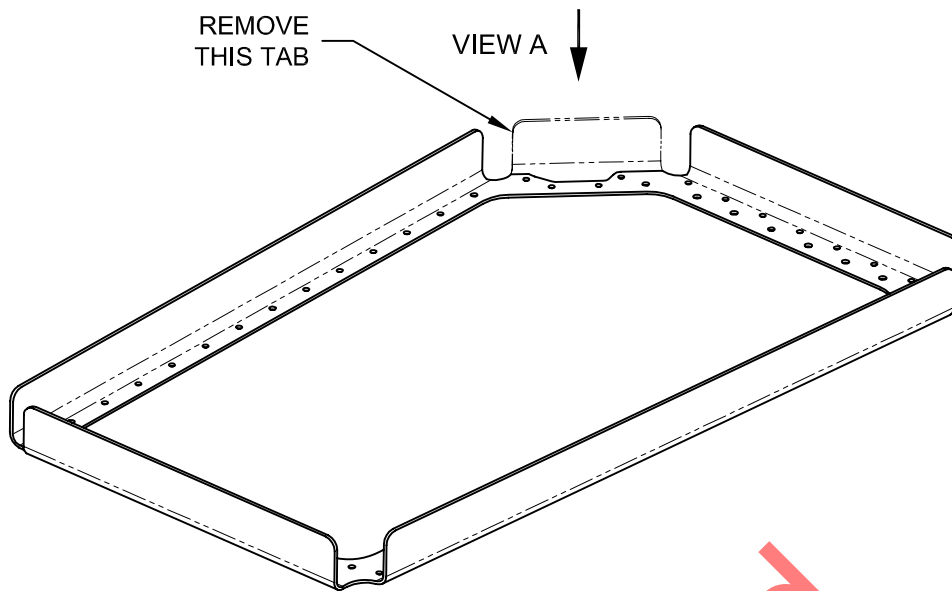
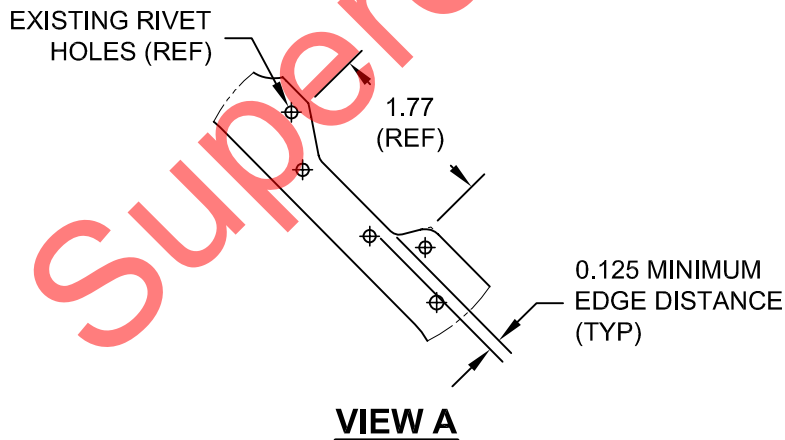


FIGURE 2: DETAIL OF D3294-1 NOTCH

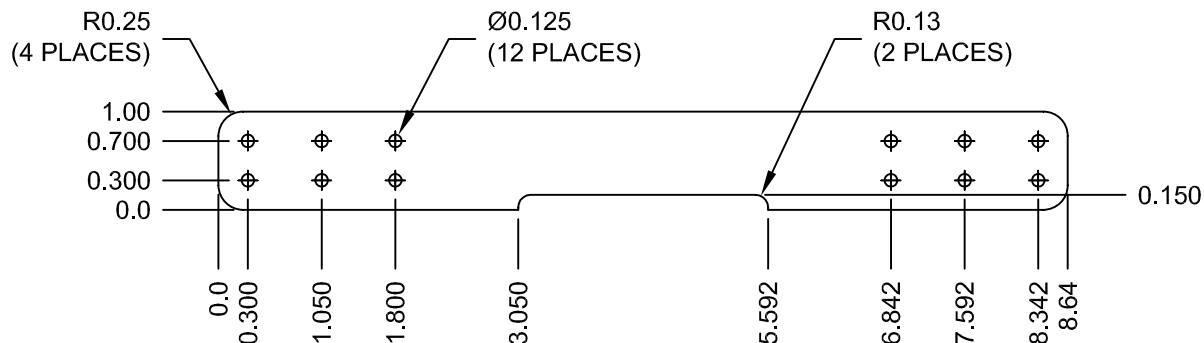


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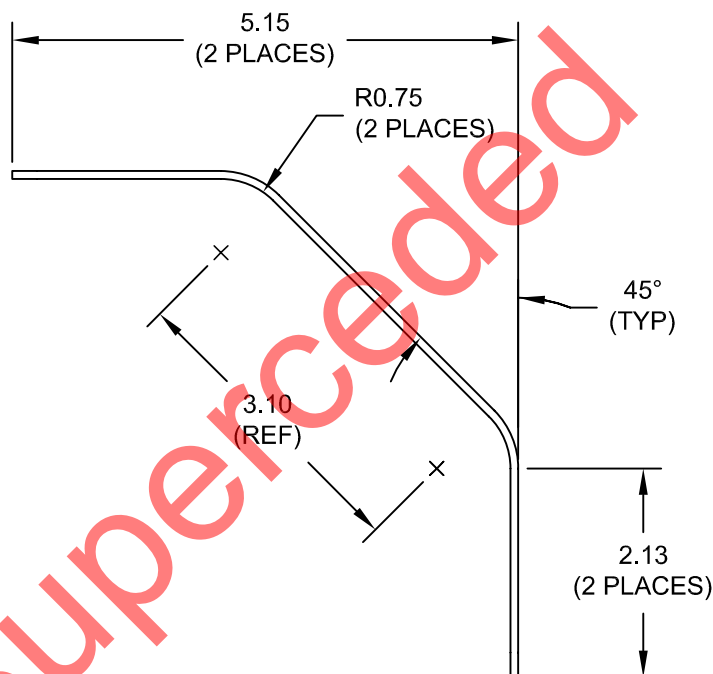
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DOUBLER FLAT PATTERN

MATERIAL: ALUMINUM 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK








DOUBLER BENDING DETAIL

FIGURE 3: DOUBLER DETAIL

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